

Work Order ID 86163

Thursday, June 21, 2012 1:23:32 PM

86163

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Item ID: D3775-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Guard

Stop ***NS2***

Start Date: 6/21/2012 Start Qty: 4.00

1

Cust Item ID:

Required Date: 6/28/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *CMF* Date: *12-06-25* Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3775

Rev B

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA742 Rev: & Dwg D3775 Rev: 2-Deburr
per dwg D3775

Manual

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

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Item ID: D3775-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Guard

Stop *NS2*

Start Date: 6/21/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/28/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: 8250

0.00

130

Packaging

Memo

0.00

Packaging

4X

SP
12-6-26

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/28 AG

MLJ 12/06/26

Picklist Print

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Work Order ID: 86163

Parent Item: D3775-1

Parent Item Name: Guard

Start Date: 6/21/2012

Required Date: 6/28/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-05-05 JLM Verified By:EC
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.500 Inventory		Purchased	No			100	f	24.0000	0.235	0.2473684			

Location

Loc Qty

Loc Code

MAT055

24

121971

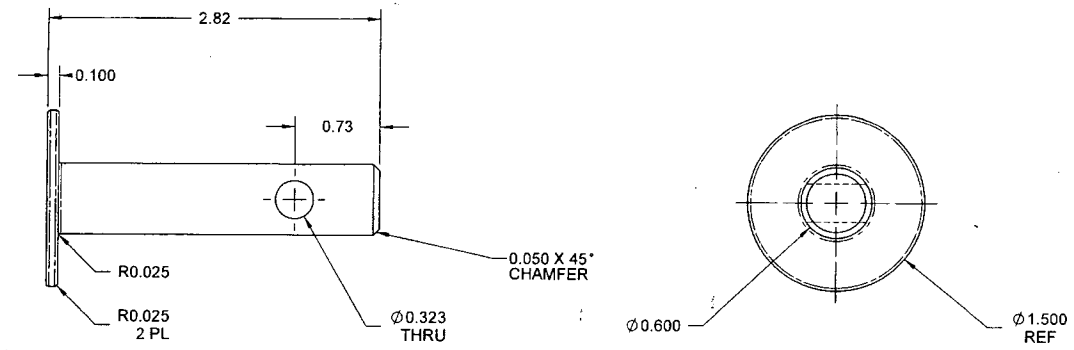
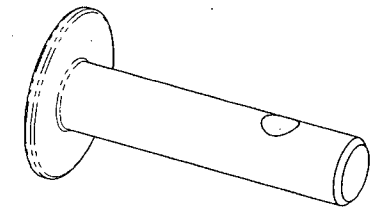
8

122042

16

1.0 f 12-06-25

#86163



D3775-1 GUARD

08.07.10/11P

- NOTES:**
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL ROUND BAR (REF. DART SPEC. M-DELRIN-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

B	RE-DESIGN -1 FOR LONGER PROFILE, ELIMINATE -3	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS		
MFG. APPR.	HS		
APPROVED	HS		
DE APPR.	HS	GUARD	
DATE	08.06.10		
		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL - NOT TO BE SUPPLIED OR THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DRAWING NO. **D3775** REV. B
SHEET 1 OF 1
TITLE **GUARD** SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries